

Date: Thursday, 12/20/2007 3:17:15 PM
User: Kim Johnston

Process Sheet

3

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MIRROR BRACKET
Job Number : 36466A02	
Estimate Number : 10144	
P.O. Number : N/A	Part Number : D20136
This Issue : 12/20/2007 S.O. No. : N/A	Drawing Number : D2013 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 29089	Material : N/A
Written By : <u>JD 07 12 21</u>	Due Date : 1/15/2008 Qty: 5 Um: Each
Checked & Approved By : <u>JD 07 12 21</u>	
Comment : Est Rev: A New Issue 05-11-01 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 1.8165 f(s)/Unit Total : 9.0825 f(s)
Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless Tubing
(M304TR0.750W.049)
Batch: B 106045 FF 10-01-08 (5)

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Punch as per template D2013-T5 and Dwg D2013

2-Flatten ends of D2013-6 tube as per Dwg D2013 using DT8545

3-Bend tube as per Dwg D2013 using Jig DT8201 identify as D2013-6.

4-Deburr as required

} FF 10-01-08 (5)
FF 11-01-08 (5)
FF 10-01-08 (5)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

5 08/01/14 (5)

4.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/01/14

Job Completion



u 08.01.14

PKY

ID + stick

c 08/01/14 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

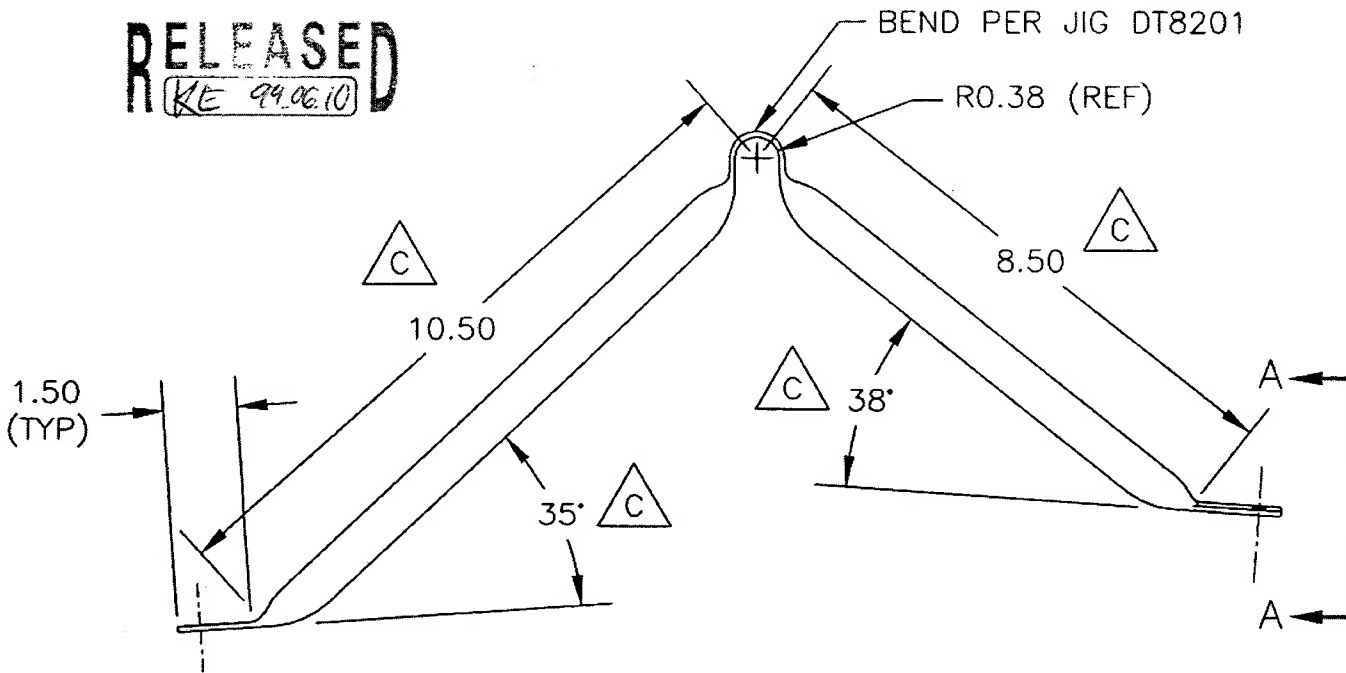
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 08/01/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

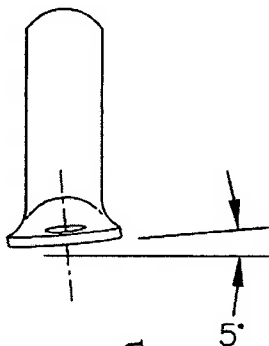
RELEASED
KE 99.06.10

DART



D2013-1 LH SHOWN
D2013-2 RH OPPOSITE
(FOR 205 MIRROR)

DRILL $\varnothing 0.257$ (TYP)
0.400 (TYP)



VIEW A-A

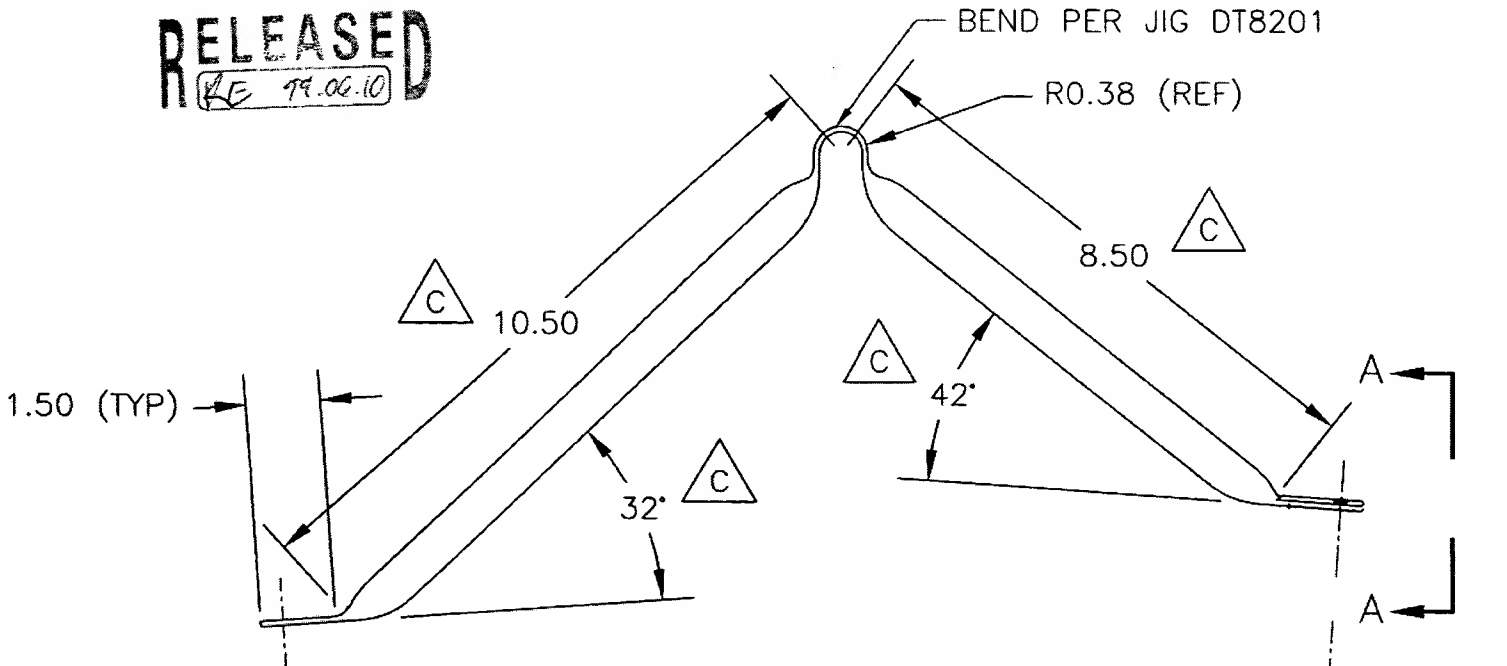
CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 OD x 0.049 WALL

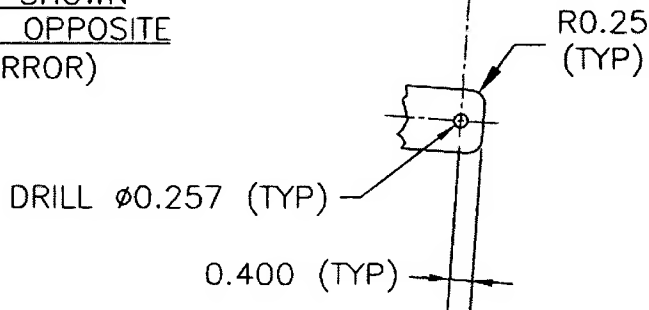
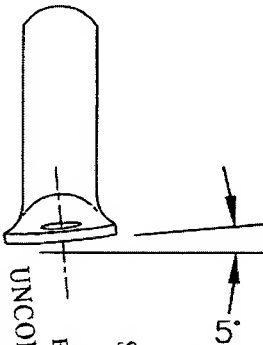
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WITHOUT NOTICE
WORK ORDER
NO 36466 A02

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
JB.	RF	
CHECKED KE	APPROVED JD	DRAWING NO. D2013
DATE 99.06.07	TITLE MIRROR BRACKET	REV. C SHEET 1 OF 3
A	90.10.22	NEW ISSUE
B	94.06.15	REDRAWN
C	99.06.07	REDRAWN, CHANGE OF DIMENSIONS

RELEASED
 RE 79.06.10



D2013-3 LH SHOWN
 D2013-4 RH OPPOSITE
 (FOR 212 MIRROR)



CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
 0.750 O.D. x 0.049 WALL

DART



DESIGN	JB	DRAWN BY	RF	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	[Signature]	DRAWING NO. D2013
DATE	99.06.07	TITLE	MIRROR BRACKET	REV. C SHEET 2 OF 3
		SCALE	NTS	

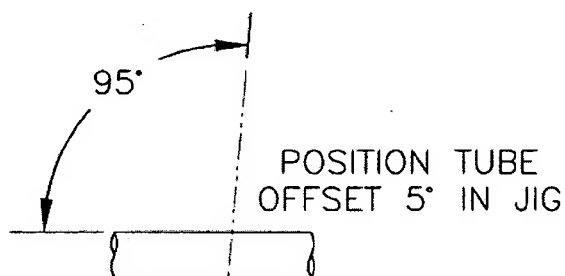
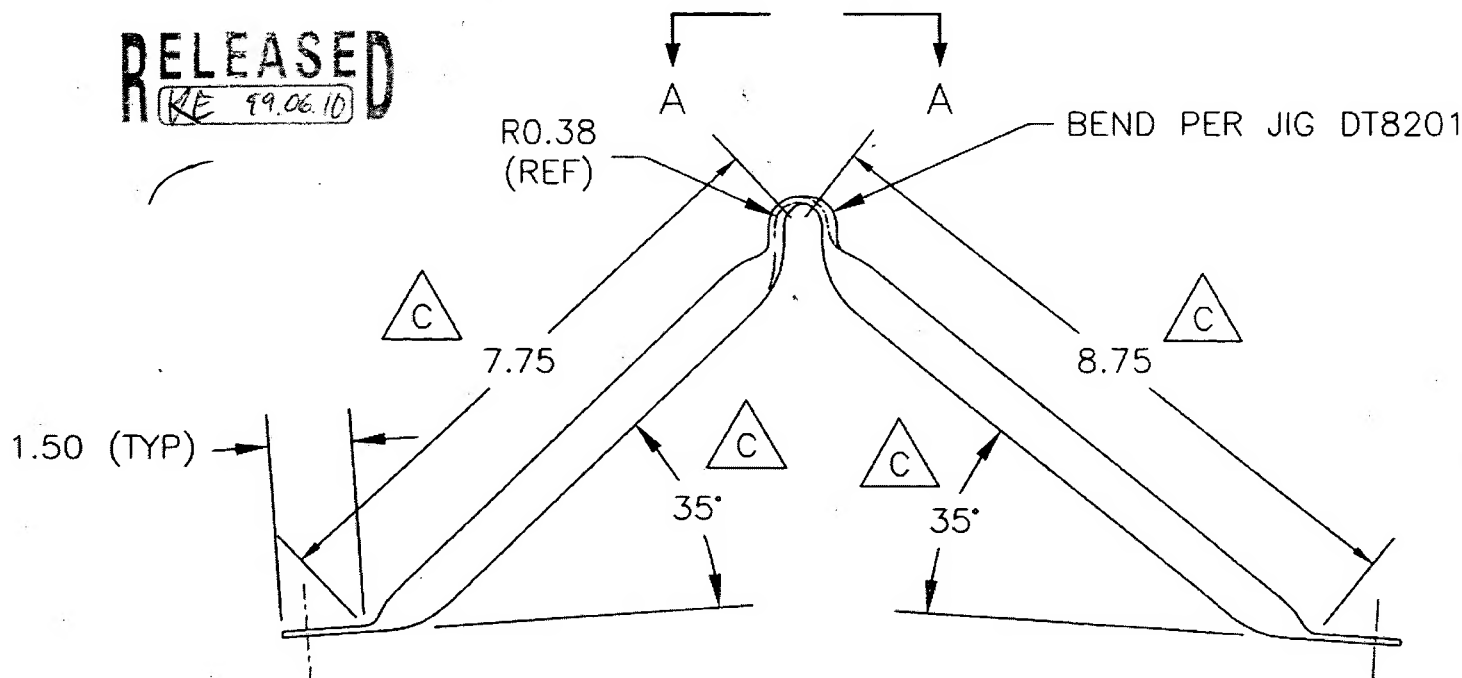
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RELEASED
(KE 99.06.10)

DART

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DESIGN	JB	DRAWN BY	RM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	KE	APPROVED	✓	DRAWING NO.	D2013
DATE	99.06.07	TITLE	MIRROR BRACKET	REV. C	SHEET 3 OF 3
				SCALE	NTS



D2013-5 LH SHOWN
D2013-6 RH OPPOSITE
(FOR 204 MIRROR)

DRILL $\varnothing 0.257$ (TYP)
R0.25 (TYP)
0.400 (TYP)

CUT LENGTH: 20.75 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

NO. 364616102
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